

**ABSTRACT**

A vise jaw assembly for supporting and securing an object to be worked upon in a vise is provided. The jaw assembly 10 has a block 14 with a plurality of apertures 16, a plurality of channels 40 passing through a portion of the block 14, a plurality of inlet holes 44, and a plurality of pins 48. Each pin 48 is located within an aperture 16 and is in slidable engagement with the aperture 16. The channels 40 can extend in a generally longitudinal direction of the block 14. Each channel has a first segment 42 in fluid communication with an inlet hole 44 and a second segment 45 in fluid communication with at least one aperture 16. At least one fluid passageway 46 extends from an inlet hole 44 to at least one aperture 16. Each pin 48 is independently deployable to a use position P1 and retractable to a non-use position P2. A plate 18 is secured to the rear surface 32 of the block 14 to enclose the channels 40. The assembly 10 further includes a means for securing 34 the plate 18 to the block 14 and a means for fixedly attaching 36 the block 14 and plate 18 to the vise 12.

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